






# Work Order ID 63335

Wednesday, October 27, 2010 3:51:46 PM

Page 1

Item ID:	D2938-1UP	Accept		Setup	Start	
Revision ID:						
Item Name:	206 Saddle Left side-unpainted				Stop	
Start Date:	10/27/2010	Start Qty:	4.00	Cust Item ID:		
Required Date:	11/11/2010	Req'd Qty:	4.00	Customer:		
Reference:						


Approvals:	Process Plan:	Date:	10-10-28	Tooling:		Date:		Run	Start	
	QC:	Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2938	Rev C								

100		HAAS CNC VERTICAL MACHINING #1	0.00	<i>aml 10/11/16</i>					
	HAAS 1	Memo	0.00	<i>B.A. 10/11/11</i>		<u>3</u>	<u>B</u>		


HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

110		CONVENTIONAL MILLING MACHINE	0.00	<i>aml 10/11/16</i>					
	Mill Conv	Memo	0.00			<u>3</u>	<u>B</u>		

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120		QC1- Inspect dimensions to dimension sheet	0.00	<i>aml 10/11/16</i>					
	QC	Memo	0.00			<u>3</u>	<u>B</u>		

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63335**

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Page 2

Item ID: D2938-1UP

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Revision ID:

Item Name: 206 Saddle Left side-unpainted

Start Date: 10/27/2010 Start Qty: 4.00

Required Date: 11/11/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00

JL 10/11/17

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

JW 10/11/17

HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

3 9

3 10-11-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Required Date: 11/11/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: 431

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/11/17 (3)

CK 10/11/17 (3)

10-11-17 (3)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, October 27, 2010 3:51:50 PM

Page 1

Work Order ID: 63335

Parent Item: D2938-1UP

Parent Item Name: 206 Saddle Left side-unpainted


Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 4.00

Required Qty: 4.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	37.0000	1	4			

Saddle Billet, 7075

### Location

### Loc Qty

### Loc Code

MAT042

37

61250

37

4.0

B.A 10/11/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	63335
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b>	D2938-1
<b>Inspection Dwg:</b> D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.120	.117	.118	.118		
B	0.100	0.140		.120	.115	.117	.116		
C	0.100	0.140		.117	.121	.121	.118		
D	0.210	0.230		.222	.223	.223	.223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.500	.500	.500			
I	1.572	1.582		1.575	1.575	1.575	1.575		
J	2.495	2.505		2.498	2.498	2.498	2.498		
K	0.257	0.262		.260	.260	.260	.260		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		.236	.235	.235	.236		
N	0.100	0.140		.113	.115	.113	.113		
O	0.540	0.560		.549	.549	.546	.548		
P	0.490	0.510		.510	.509	.510	.509		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.720	2.760		2.741	2.741	2.742	2.741		
S	0.240	0.270		.253	.253	.254	.253		
T	0.100	0.180		.130	.130	.131	.132		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.365	1.365	1.365	1.365		
W	0.316	0.321		.317	.317	.317	.317		
X	1.250	1.270		1.258	1.259	1.257	1.260		
Y	1.565	1.585		1.572	1.572	1.571	1.573		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	aml
Date:	10/6/16

Audited by:	SL
Date:	10/11/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

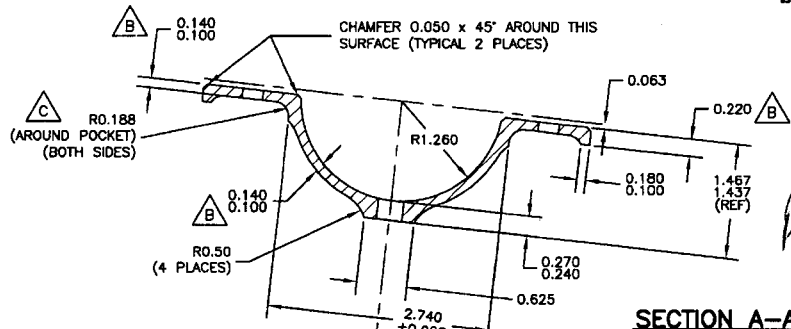
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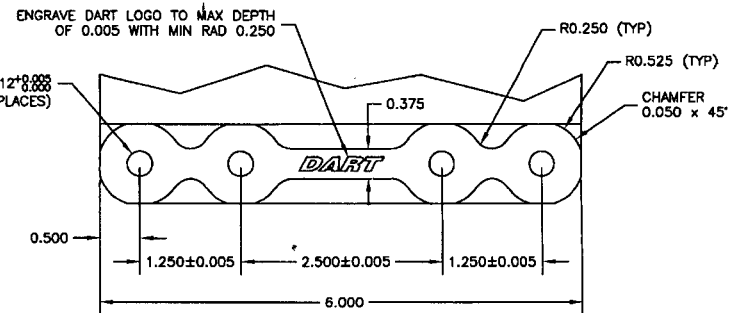
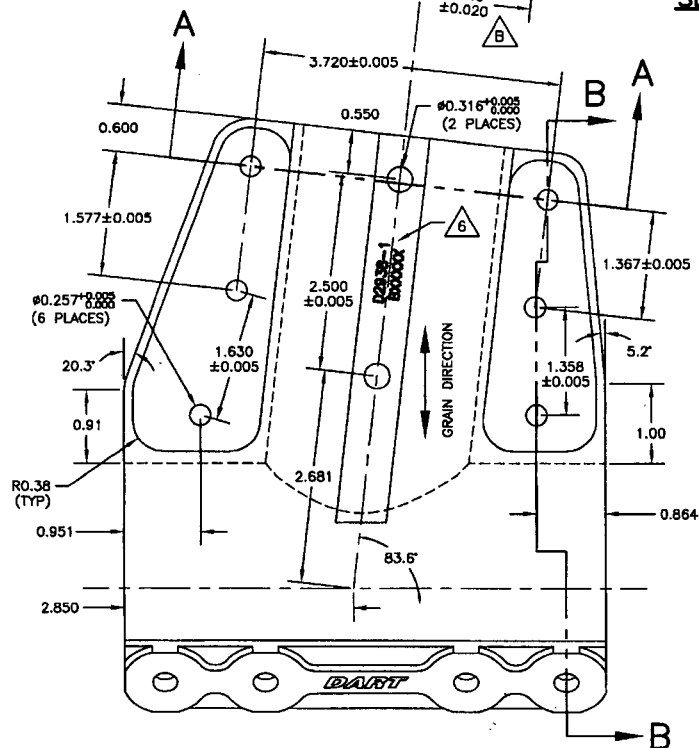
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SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 63335

8101026

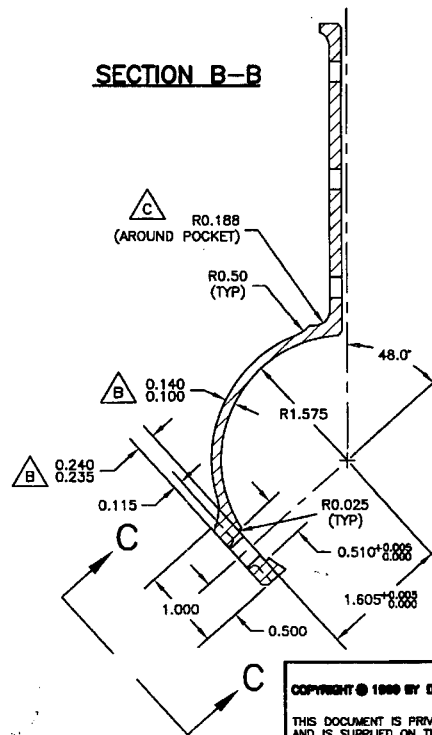


SECTION A-A



VIEW C-C

SECTION B-B



D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	PH	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE SADDLE OUTSIDE
		DART DART AEROSPACE USA, INC. BELLEVUE, WA
		DRAWING NO. D2938
		REV. C
		SHEET 1 OF 1
		SCALE 2:3

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DART AEROSPACE USA, INC.

07.02.12

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